DART AEROSPACE LTD.

Work Order: 212.48

Description: Saddle Fitting, Fwd (Outboard/Inboard)

Part Number: D2571/D2572

Drawing: D2571 Rev. D/D2572 Rev. D

Qty: 88

Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveller	M		60
	ļ	Dwg not required	78	04.07.13	6
2	MV	Make from D6101-007 billet for D2571	1-0-		
		Ensure that grain is along 7.75" length	_	1.1	8
		Batch No: \$ 26984	Ep	04/08/03	0
3	MV	Make from D6101-005 billet for D2572			
		Ensure that grain is along 5.00" length	Ep	1 ;	
		Batch No: R70583	9	04/08/03	8
4	MV	Fixturing W/O No. 11/A		101	0
		Fixturing Inspection last completed 04/68/3by	Er	cil08/03	8
5	MV	Program Batch No. B2/298		1.1.	6
		Double check by:	00	04/08/03	Ö
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached	180	1.1	
		Dimension Sheets	9	004/09/0	8
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached	FA	101	22
	1.0.	Dimension Sheets	4)	04/08/09	83
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached	En	1010	
	N 43 4	Dimension Sheets	17/	oylogles	8
9	MV	Machine keyway as per dwg D2571 & D2572	60	1010	6
10	MV	Debugge and seems of the orbital and the		04/08/05	8
10	IVIV	Deburr and remove all machining marks	60	04/08/05	8
11	MV	Tumble for 20 minutes in sense shap edges # 04.00.21	97	04168165	6
1 1	IVIV	Tumble for 20 timbles to show shap tales if	Ep	04/08/09	6
12	QC1	Inspect all dimensions to dimension sheets		09(80/0)	c-
12	QCI	inspect all differsions to differsion sheets	ϵ_{p}	odoslos	8
13	QC7	Second inspection		040000	
, 0	Q07	Geeona inspection	135	04.05-10	8
14	FP	Acid etch and alodine as per QSI 005 4.1	100	0-1.0310	Q_{-}
• •		Tiona otori aria albania do por Qor 000 4.7	911	G1.58 10	X
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	100		
		1. 2.1.2.1 2.2.1.1.g., 2.2.2.2 7.1.1.2 (1.2.2.1) por qui con 1.2	11111	04 08 10	8
16	QC3	Inspect Powder Coat	(")		
		*	-	04.08.11	8
17	ST	Identify and Stock.	1		
		·	CX	04/08/12	8
18	AC		1 1		·•
		Cost / Part ///. 95 89.60 Close W/O/64.43 83.88	540	04-08-13	8
19	DC		TV		m
		Inspection Level 21		04.08.16	8

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	/
Н	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ KF	Λ

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